









Work Order ID 58300

Monday, May 03, 2010 10:35:05 AM

Page 1

Item ID: D3805-047 Accept  Setup Start 
Revision ID: 
Item Name: Wearplate Assembly Aft, High Gear Stop 
Start Date: 5/3/2010 Start Qty: 6.00  Cust Item ID:
Required Date: 5/7/2010 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: mf Date: 10-5-3 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3805	Rev A								

100  0.00

Large Fab  Memo 0.00

Large Fab
1- on D3806-7, fill cut outs-with hardcoat welding rod as per dwg D3805
2059 B Hardcoat Welding Rod
BATCH#: M114460
2-weld D3806-7 to wearplate by positioning holes together as per dwg D3805
304 S.S. Welding Rod
BATCH #: m 102427
3-Transfer drill holes in bar

110  QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC  Memo 0.00

Quality Control

EL 10-5-5 (X5)

(5) AD 10.05.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 58300

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Page 2

Item ID: D3805-047 Accept  Setup Start 
Revision ID: Stop 
Item Name: Wearplate Assembly Aft, High Gear
Start Date: 5/3/2010 Start Qty: 6.00  Cust Item ID:
Required Date: 5/7/2010 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	S 10/05/06			<u>X5</u>			
130  Powdercoat Powder Coating	M112588 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 START: 7:00AM Temp: 320°F Fin: 7:30AM Memo	0.00 0.00	⇒ M 10/05/07			<u>X5</u>	<u>6</u>		
140  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	5 BR 10-5-7.						

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Page 3

Item ID: D3805-047

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly Aft, High Gear

Start Date: 5/3/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/7/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

0.00



Small Fab

Memo

0.00

Small Fab

1- Bond D3807-7 gasket to inner surface of wearplate using Scotch-grip adhesive.

A/R Scotch-grip

batch: M 113124

Sp 10/05/10

(5)

160

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

Sp 10/05/10

(25)

170

0.00



Packaging

Identify as per dwg & Stock Location: PPN

Memo

0.00

Packaging

58518

Sp 10/05/10 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 58300

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Page 4

Item ID: D3805-047

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly Aft, High Gear

Start Date: 5/3/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/7/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/10
MF
10-5-10

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NOTE: Date & initial all entries

Picklist Print

Monday, May 03, 2010 10:35:05 AM

Page 1

Work Order ID: 58300

Parent Item: D3805-047

Parent Item Name: Wearplate Assembly Aft, High Gear

Comments: IPP RevB: add transfer drill wearplate to bar DD 09.11.05 verified by:EC

Start Date: 5/3/2010

Required Date: 5/7/2010

Start Qty: 6.00

Required Qty: 6.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D3805-7		Manufactured	No			100	Each	6.0000	1			
											EL 10-5-5	
Plate												

Location	Loc Qty	Loc Code
WA	6	
52839	2	
56866	4	

D3806-7		Manufactured	No			100	Each	8.0000	1			
											EL 10-5-4	
Bar												

Location	Loc Qty	Loc Code
WA	8	
46787	4	
52854	4	

D3807-7		Manufactured	No			150	Each	6.0000	1			
												
Gasket												

Location	Loc Qty	Loc Code
FP012	6	
52838	6	

5 80 10/05/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

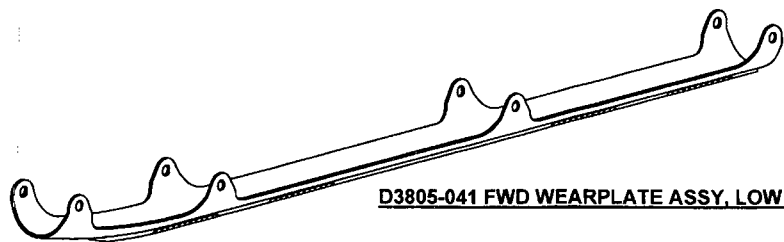
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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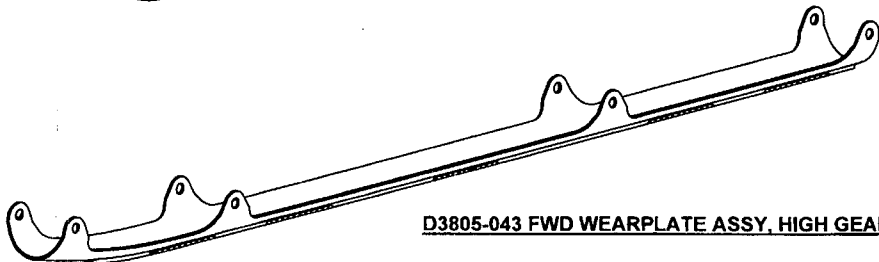
NOTE: Date & initial all entries

8 7 6 5 4

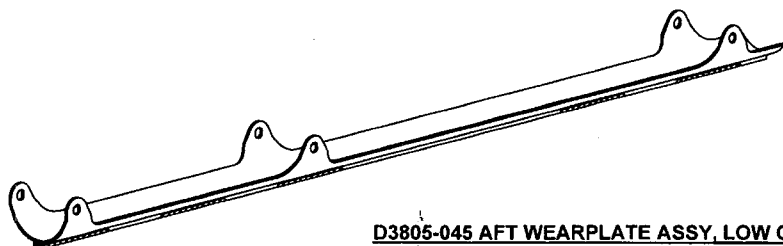
3 2 1



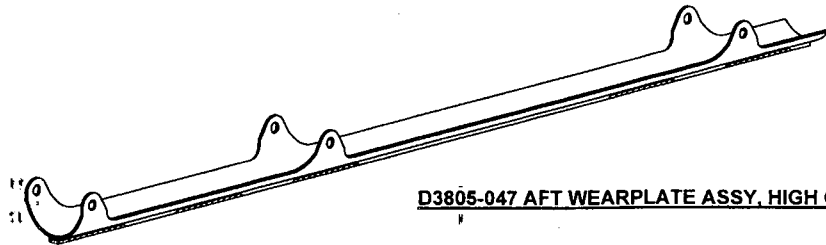
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

8 7 6 5 4

3 2 1

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

#58300

RELEASED
47 07.03.03
Per ECN 07-538

A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	47	DART AEROSPACE USA, INC.	
DRAWN	47	PORT HADLOCK, WA	
CHECKED	47	DRAWING NO.	REV. A
MFG. APPR.	47	D3805	SHEET 1 OF 8
APPROVED	47	TITLE	SCALE
DE APPR.	47	WEARPLATE ASSY	NTS
DATE	08.11.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONDUCT OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

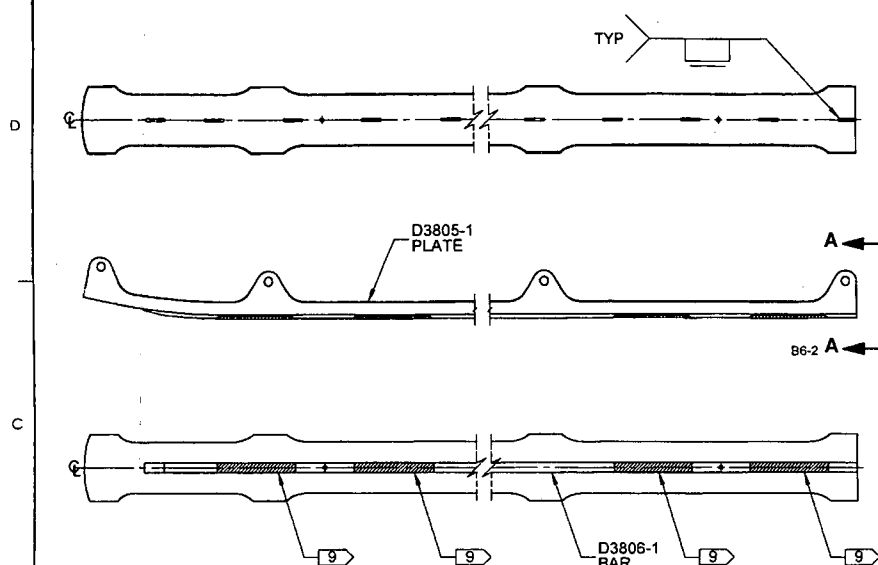
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

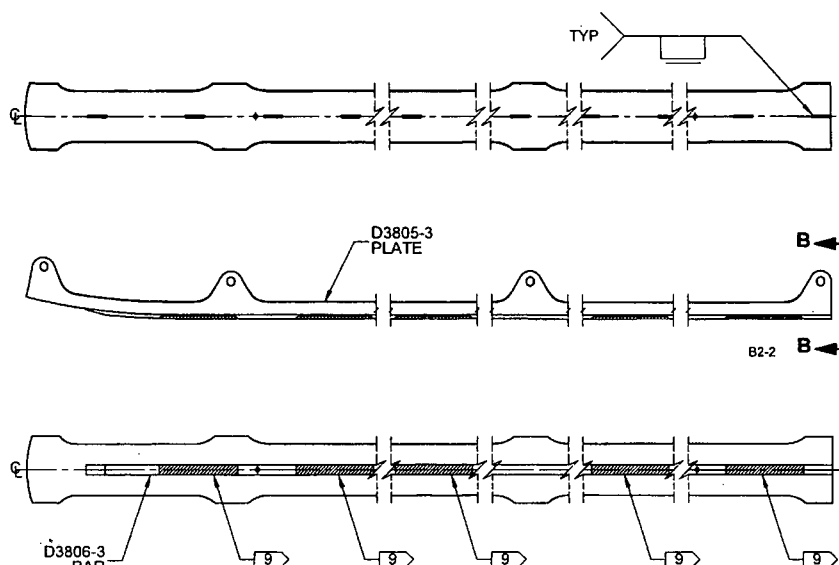
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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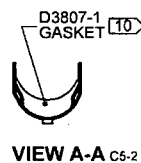
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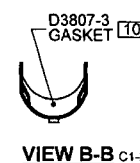
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



VIEW A-A C5-2



VIEW B-B C1-2

#58300

RELEASED
09.03.03

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-041 = 3.79 lbs; D3805-043 = 4.36 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN	JP	DART AEROSPACE USA, INC.	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3805	SHEET 2 OF 8
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEARPLATE ASSY	NTS
DATE	08.11.21	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

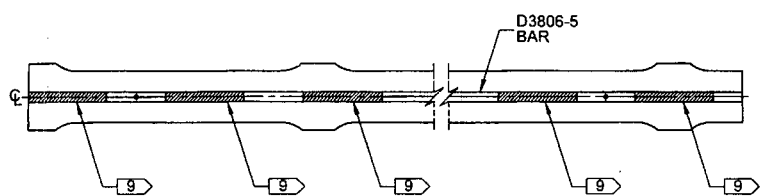
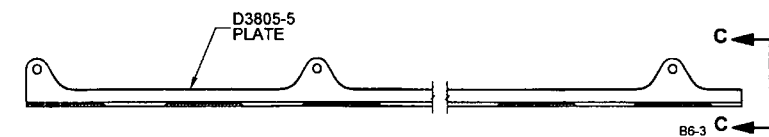
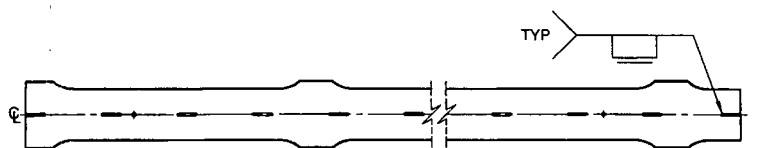
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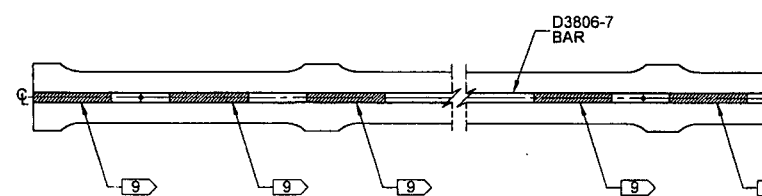
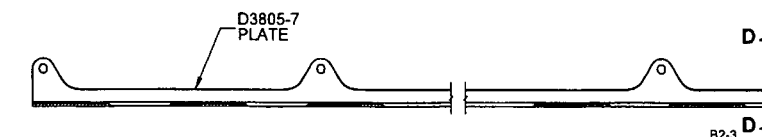
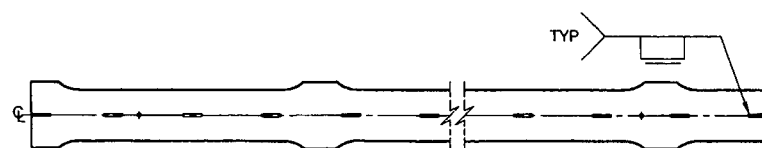
8 7 6 5 4 3 2 1



D3805-045 AFT WEARPLATE ASSY.



VIEW C-C C5-3



D3805-047 AFT WEARPLATE ASSY.



VIEW D-D C1-3

#58300

RELEASED
09.03.07

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-045 = 3.93 lbs; D3805-047 = 4.21 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN	10	DART AEROSPACE USA, INC.	
DRAWN	10	PORT HADLOCK, WA	
CHECKED	15	DRAWING NO.	REV. A
MFG. APPR.	10	D3805	SHEET 3 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	WEARPLATE ASSY	NTS
DATE	08.11.21	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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NOTE: Date & initial all entries

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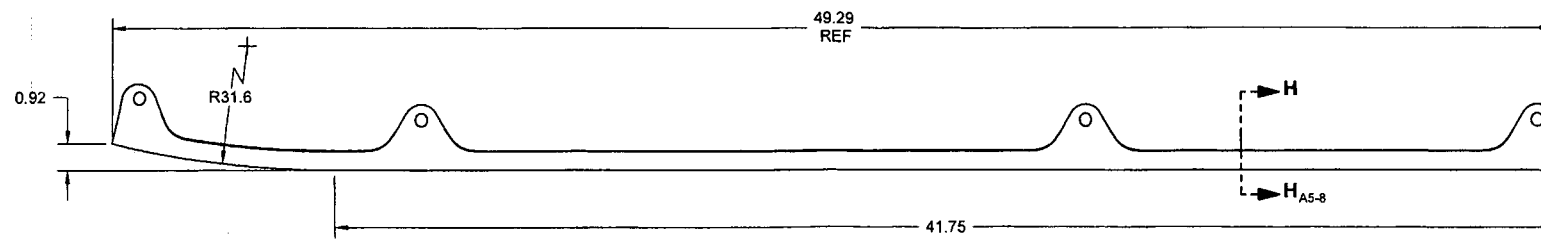
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

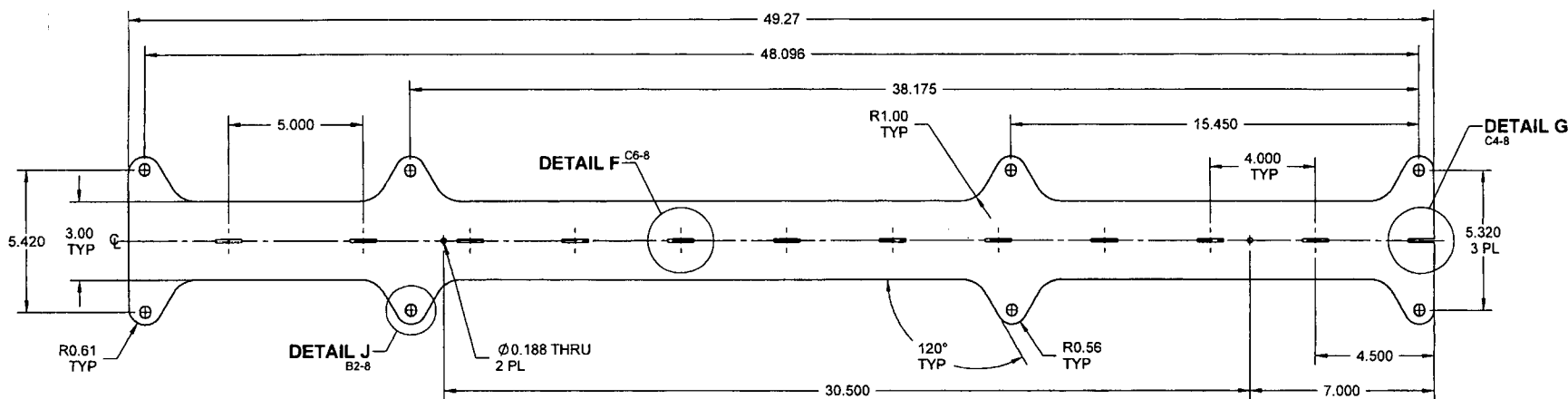
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3805-3 PLATE
(MAKE FROM D3805-3F)



D3805-3F PLATE

\$58300

RELEASED
04.07.07

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.37 lbs

DESIGN	147	DART AEROSPACE USA, INC.	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	AS	D3805	SHEET 5 OF 8
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	WEARPLATE ASSY	NTS
DATE	08.11.21	<small>COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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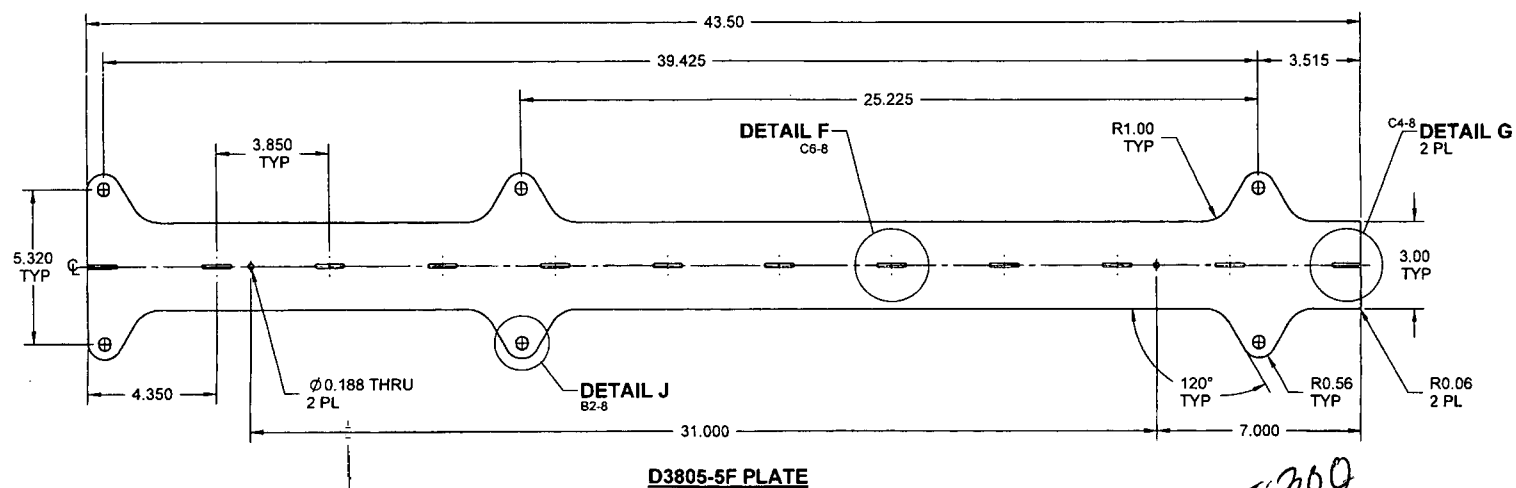
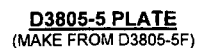
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



#58300

RELEASED
9 04.03.03

- NOTES:**
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
 18 GAUGE (0.050 THICK)
 REF. DART SPEC. M304S18GA
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 2.06 lbs

DESIGN	<i>JP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D3805 TITLE WEARPLATE ASSY COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THE DESIGN OR INVENTION IS PROTECTED BY THE PATENT CONVENTION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	REV. A
DRAWN	<i>JP</i>		SHEET 8 OF 8
CHECKED	<i>AS</i>		SCALE
MFG. APPR.	<i>JP</i>		NTS
APPROVED	<i>JP</i>		
DE APPR.	<i>JP</i>		
DATE	08.11.21		

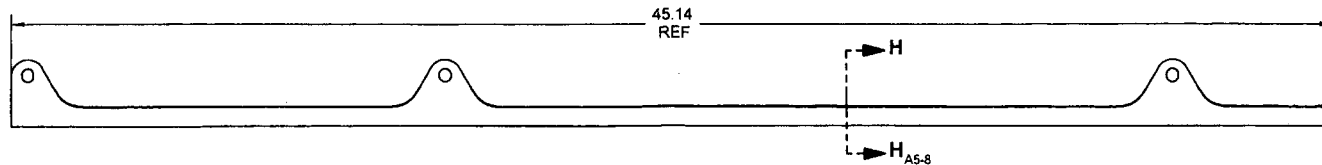
W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

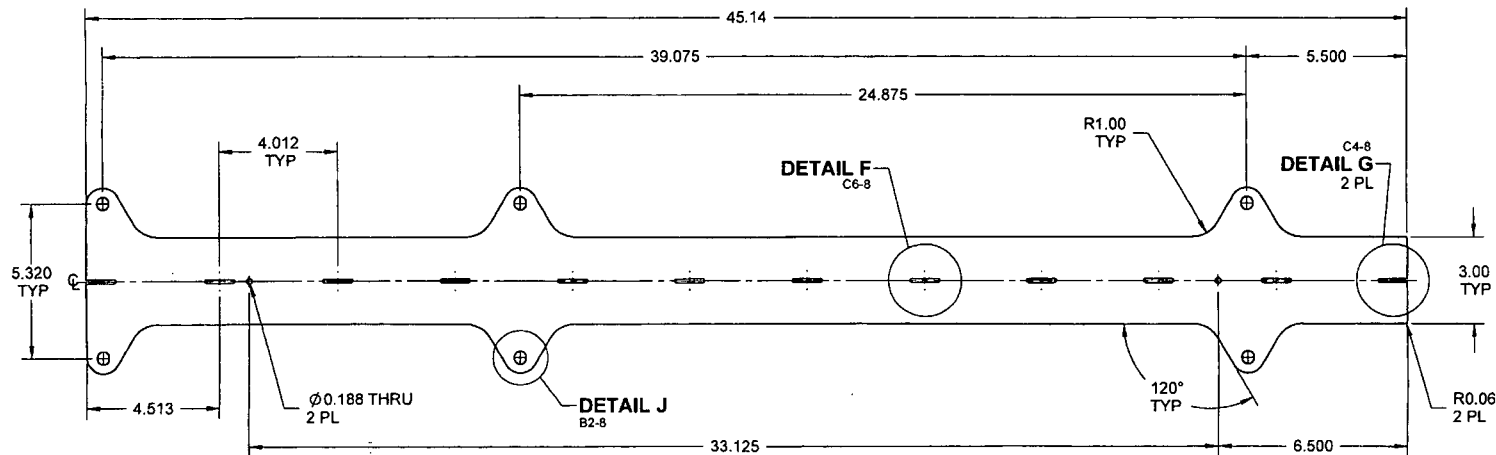
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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D3805-7 PLATE
(MAKE FROM D3805-7F)



D3805-7F PLATE

#58300
RELEASED
08.03.23

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

DESIGN	49	DART AEROSPACE USA, INC.	
DRAWN	6	PORT HADLOCK, WA	
CHECKED	ALS	DRAWING NO. D3805	REV. A
MFG. APPR.	18	SHEET 7 OF 8	
APPROVED	24	TITLE	SCALE
DE APPR.	18	WEARPLATE ASSY	NTS
DATE	08.11.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONVICTION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

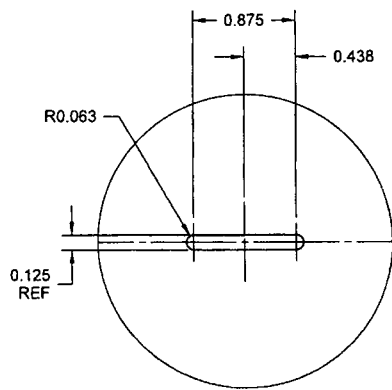
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

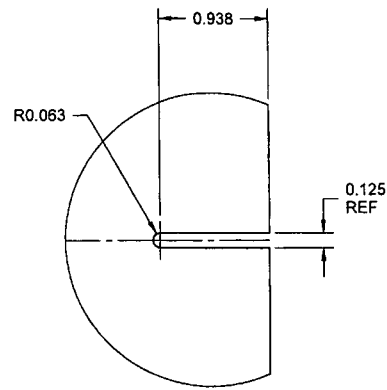
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



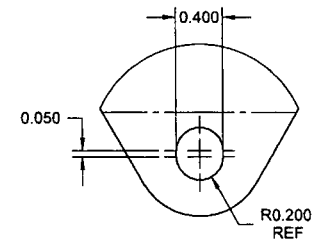
DETAIL F
SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



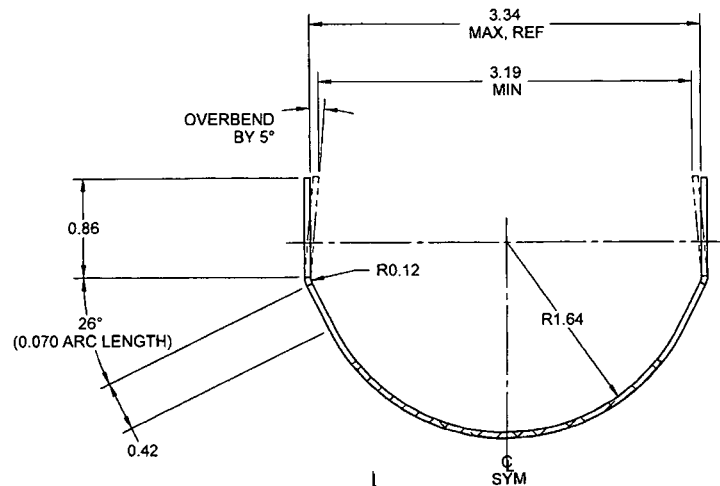
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

#58300

RELEASED
47-07-07-07

DESIGN	19	DART AEROSPACE USA, INC.	
DRAWN	15	PORT HADLOCK, WA	
CHECKED	15	DRAWING NO.	REV. A
MFG. APPR.	15	D3805	SHEET 8 OF 8
APPROVED	15	TITLE	SCALE
DE APPR.	15	WEARPLATE ASSY	
DATE	08.11.21	NTS	
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W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries